

Date: Wednesday, 11/22/2006 1:39:15 PM
 User: Kim Johnston

Process Sheet

SPLIP?

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 29646 -1
 Estimate Number : 10256
 P.O. Number : N/A Part Number : D22303
 This Issue : 11/22/2006 S.O. No. : N/A Drawing Number : D2230 REV F
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : F
 Previous Run : 29601 Material : N/A
 Due Date : 12/10/2006 Qty: 300 Um: Each
 Written By : 06 11 22
 Checked & Approved By : 06 11 22
 Comment : Est D 00.05 18 Added inspection level 8, and removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total: 21.5145 f(s)
 Lug Extrusion
 D2423
 Batch: 23779

M8/56 06/11/22 300

2.0 BAND SAW BAND SAW



Comment: Band Saw
 Cut D2423 extrusion to 0.82"
 Batch: 23779

M8/56 06/11/22 300

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2230-3
 Check for crack while loading into the machine.

Issue P.O 2556

c206/11/24

Machine per drawing D2230 Rev.F

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Review + Inspect for

06/12/12 (186)

tensit 02m29e 146

5.0 QC5 SECOND CHECK



Comment: SECOND CHECK

Inspect level 5

Feb 12.13 (186)
 counted

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 29646

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble and deburr rough edges after tumbling

N/A

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

gk/a.m

06/12/22

186
306

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

m 08 12 27

186
306
306

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

m 102391

gk/a.m

06/12/27

186

306 X

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/INSPECT POWDER COAT

PU 7/1/02

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51373

186

07/10/02

PU 7/1/12

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/02

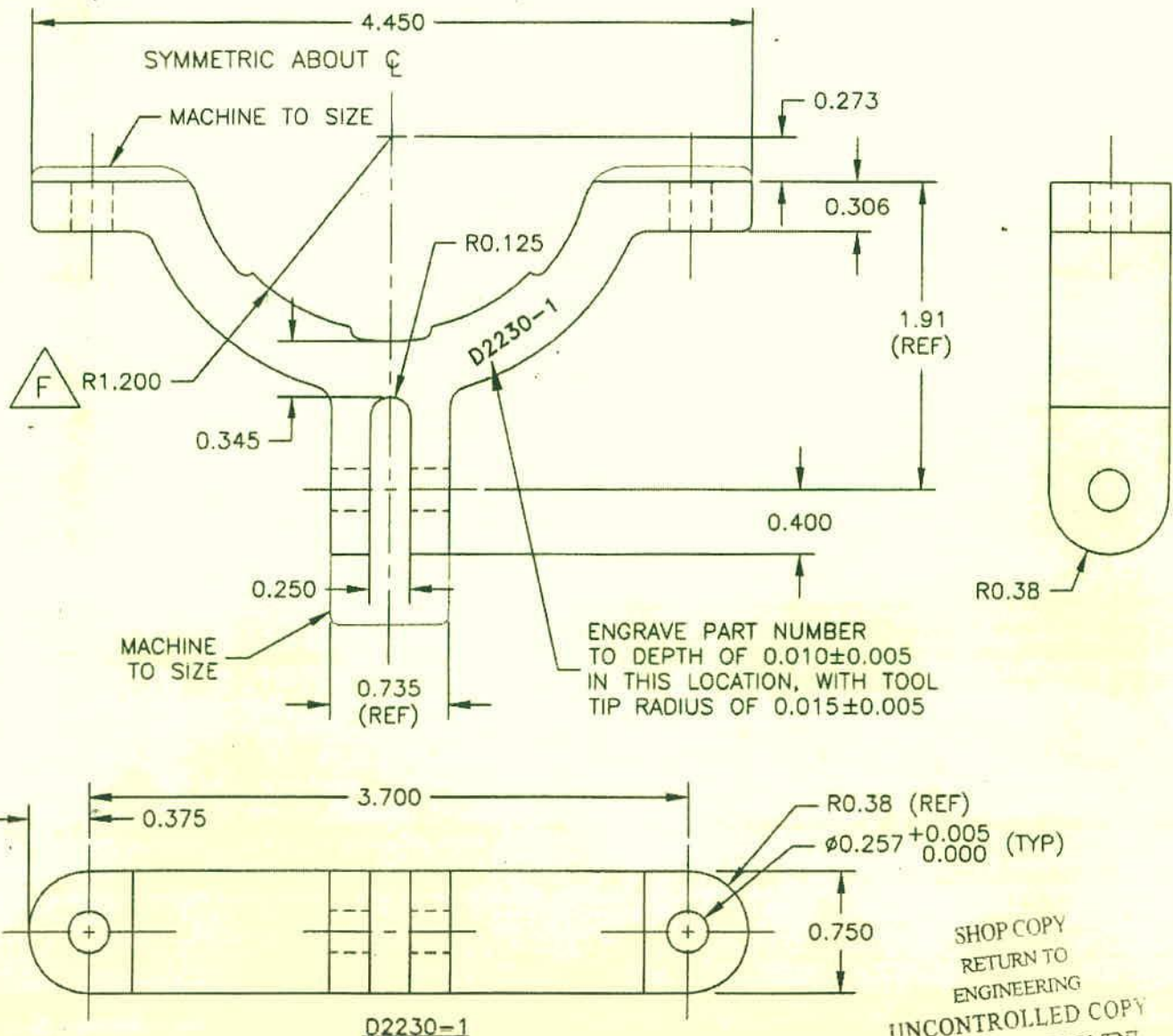
Job Completion



C 07/01/02

DART

| | | | | |
|---------|----------|-----------------------------|--------------|---|
| DESIGN | CP | DRAWN BY | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | # | APPROVED | # | DRAWING NO. D2230 |
| DATE | 99.12.13 | TITLE | MOUNTING LUG | REV. F SHEET 1 OF 2 |
| C | 94.03.30 | RE-DESIGN | | SCALE 1:1 |
| D | 95.01.04 | RE-DESIGN | | |
| E | 95.01.04 | RE-DESIGN | | |
| F | 99.12.13 | REDESIGN; R1.200 WAS R1.100 | | |

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

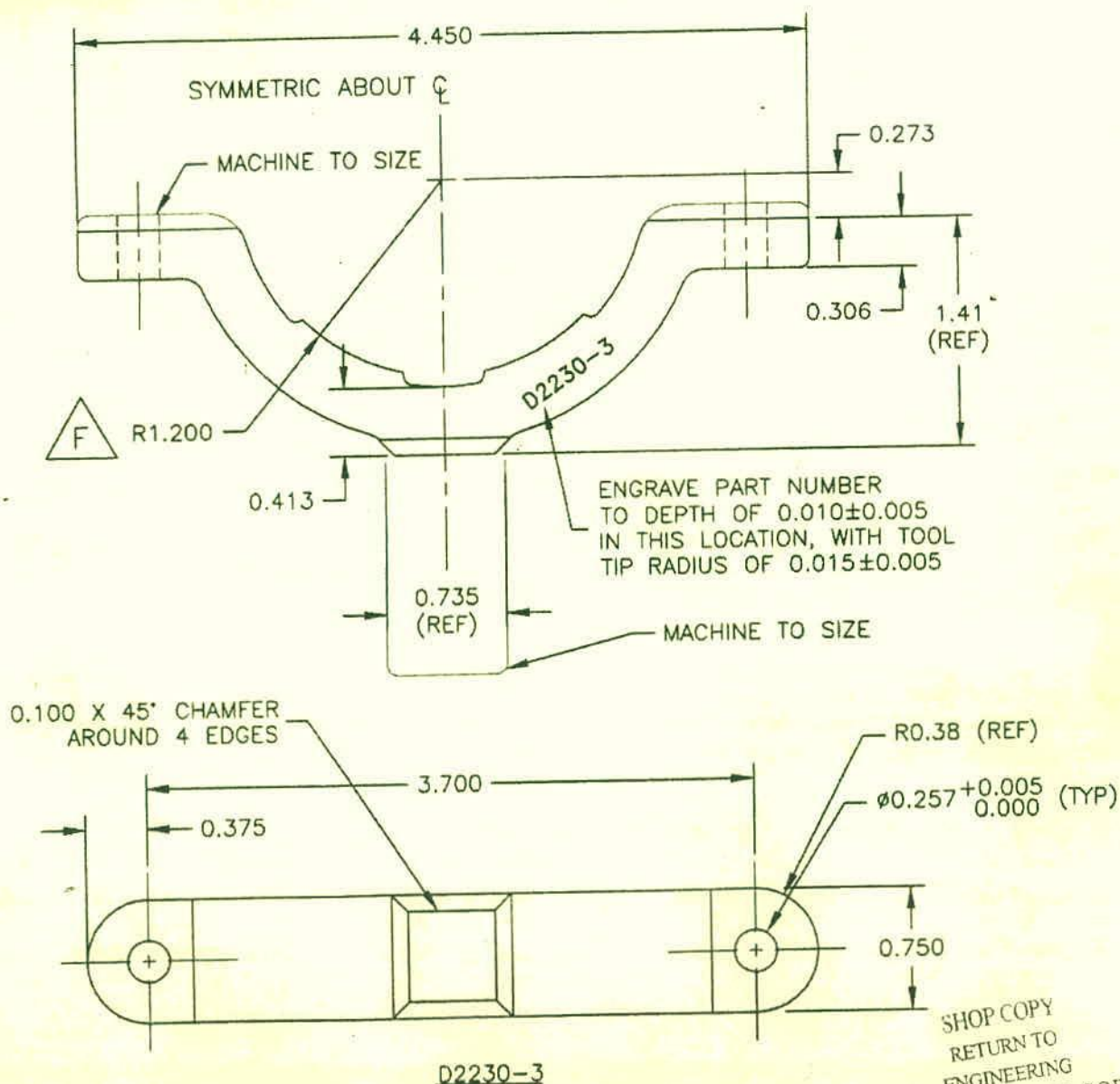
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 29646



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2230 | REV. F SHEET 2 OF 2 |
| DATE 99.12.13 | TITLE MOUNTING LUG | | SCALE 1:1 |

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 29646



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

186

D2230-3

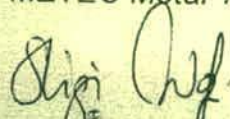
Lug B29646

2556

MATERIAL: supplied by DART D2423 B23779

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Shigi (Regula) Walz

Vankleek Hill, December 12, 2006

A large, stylized handwritten signature in blue ink, likely belonging to a representative of METEC Metal Technology Inc.

